Work Order			V 11					-	M*	N	Page 1	-
Item ID: LE Revision ID: Item Name:	)3182-1 <sup>5</sup> Hinge			Accept					Setup	Start Stop		
Start Date: 3 Required Date: 3 Reference:	:/16/2011 :/25/2011	Start Qty: 4.00 Req'd Qty: 4.00			Cust Item Customer							
• •	Process Plan	n:/[/	Date:////3-1// Date:	Tooling: SPC (Y/N):		)ate: )ate:			Run	Start Stop		-
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty	•	Reject Insp. Number Stamp	
Draw Nbr	Revi	sion Nbr	MAANITA VIII VIII VIII VIII VIII VIII VIII V									_
D3182	Rev A	A										
100 Waterjet		FLOW WATER JET		0.00	. ·				u~ <u>3</u>	- <u>)  </u>		
FLOW CNC Waterjet		I-Cut as pe Deburr if no	r Dwg D3182 □ Dwg Rev; ecessary	□Prog Rev:_	□2-						(4)	
		QC2- Inspect parts off n	nachine FAI/FAIB	0.00				Ĺ'n	<u> </u>	- 27		
QC Quality Control		Memo		0.00						~(		

120 QC

Memo Quality Control

QC8- Inspect parts - second check

	-									
W/O:			V	VORK ORDER CH	IANGES				*	
DATE	STEP	PRO	OCEDURE CH	IANGE		Ву	Date Qt	Approval  Y Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Ca	tegory:	NCI	R: Yes	No DQA: _	Date: _		
	R	esolution:	Disposit	ion:	QA	N/C Clo	sed:	Date: _		
NCR:		•	WORK OR	DER NON-CONFO	DRMANCE	(NCR	)			
DATE	STEP	Description of NC		Section B	Ciam 0	Verificatio		Approval		
DAIL	JILF	Section A	Initial Chief Eng	Action Descri	ption 	Sign & Date	Section C	gn & Section C Date	Chief Eng	QC Inspector
		,								

150

Quality Control

Packaging

Memo

Packaging

Identify as per dwg & Stock Location: CAA

\*\*\*\*\*STOCK IN BASKET CELL\*\*\*\*\*

0.00

0.00

11-07-23

· · · · · ·										
W/O:		***************************************	WC	ORK ORDER CHANG	ES			1		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
			111111111111111111111111111111111111111							
Part No	*	PAR #:	Fault Cate	gory:	_ NCR: Yes	No <b>DQA</b> :	Date: _			
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NCR:		1	WORK ORDI	ER NON-CONFORMA	ANCE (NCR	)				
DATE	STEP	Description of NC			ion B	Verification	Approval	Approval		
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
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W	ork	Or	der	ID	673	47
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Wednesday, March 16, 2011 10:54:53 AM



Page 3

Item ID:

D3182-1

Accept

Setup Start

**Revision ID:** 

**Start Date:** 

Hinge Item Name:

3/16/2011 Start Qty: 4.00

Req'd Qty: 4.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Operation

Date:

Tooling:

Date:

Run

Start

Stop

Required Date: 3/25/2011

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/

Work Center ID

Description

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject

Insp.

160

Memo

0.00

Qty

Reject Number

Stamp

Quality Control

W/O:			V	ORK ORD	ER CHANG	GES					7
DATE	STEP	PRO	CEDURE CH	IANGE	•		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:		_ NCF	R: Yes	No <b>DQ</b>	A:	Date:	
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DATE	STEP	Description of NC				tion B		Verific	cation	Approval	Approval
DAIC	SIEF	Section A	Initial Chief Eng		1 Description Chief Eng		Sign & Date	Secti	ion C	Chief Eng	QC inspector
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		,									

## **Picklist Print**

Wednesday, March 16, 2011 10:55:02 AM

Work Order ID: 67347

Parent Item:

D3182-1

Parent Item Name: Hinge



**Start Date: 3/16/2011** 

Required Date: 3/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

□A□03.01.29□New issue□KJ/RF□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No		100	sf	37.1792	0.0596	0.250947			
									195	11-2-21		

304/316 0.125 Sheet

679158 Location Loc Qty Loc Code 37.179158 MAT 116623 37.179158



									,	
W/O:			V	ORK ORDER CHANGE	ES			····	-	ŕ
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Ca	tegory:	NCR: Ye	s No	DQ.	<b>\</b> :	_ Date:	
	R	esolution:	Disposit	ion:	QA: N/C Closed: Date:					
NCR:			WORK OR	DER NON-CONFORMA	NCE (N	CR)				
DATE	STEP	<b>Description of NC</b> Section A		Corrective Action Section			Verific	ation	Approval	Approval
DAIL	SIEP		Initial Chief Eng	Action Description Chief Eng	Sig Da		Section C	Chief Eng	QC Inspector	
-146					,					

DART AEROSPACE LTD	Work Order:	61347
Description: Hinge	Part Number:	D3182-1
Inspection Dwg: D3182 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

	<b>L</b>				<b>J</b> .	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.718	+/-0.010	3,707	ي		V 1802	
Ø0.257	+0.006/-0.001	256	>		ν	
2.304	+/-0.010	756	b		V	
R0.125	+/-0.010	761.	6		R.G.	
						- All All All All All All All All All Al

Measured by:	B	Audited by:	8	Prototype Approval:	N/A
Date:	11-3-71	Date:	u103/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.10.12	New Issue	KJ/JLM	
В	08.01.16	3.718 was 3.178	KJ/EC/DD	78

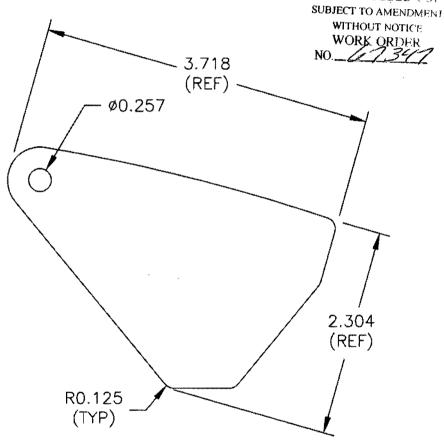
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W/O:		37-7-13-4-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-1-	WC	RK ORDER CHAN	GES					
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			***************************************							
Part No		PAR #:	Fault Cate	Jory:	NCR: Yes	No <b>DQ</b>	A:	Date:		
	Res	olution:	Disposition	Disposition: QA: N/C Closed: Date:						
NCR:			WORK ORDE	R NON-CONFORM	MANCE (NC	R)				
DATE	STEP	Description of NC						Approval	Approval	
DAIL	JILF	Section A	Initial Chief Eng	Sign Dat		ion C	Chief Eng	QC Inspector		
	,									
		·	1 2020 - 1 2020							





	DESIGN	4	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
Ì	CHECK	ED	APPROVED	DRAWING NO.	REV. A		
1	<	#	d	D3182	SHEET 1 OF 1		
Ì	DATE			TITLE	SCALE		
	03.01.21			HINGE	1:1		
T	Α		03.01.21	NEW ISSUE	•		

SHOP COPY **RETURN TO ENGINEERING** UNCONTROLLED COPY



#### D3182-1 HINGE

- 1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG" 2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK (REF DART SPEC. M304S11GA)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Dart	Aer	osi	oac	e Ltd

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W/O:	-		V	VORK ORDER CH	IANGES					
DATE	STEP	PROCI	HANGE	В	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No		PAR #:								
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DATE	STEP	Description of NC	Corrective Action Section B			Cian 0		ication	Approval	Approval
DALL	9, 1,	Section A	<b>Initial</b> Chief Eng	Action Descri Chief Eng	ption	Sign & Date	Section C		Chief Eng	QC Inspector
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